

Amendments to the Claims:

The following listing of claims will replace all prior versions, and listings, of claims in the application:

1-8. (Canceled)

9. (Currently Amended) A tire building system ~~comprising~~ comprising:

a first building unit, said first building unit including:

a toroidal building drum having: a bead lock portion configured to fix a pair of bead cores; and a scalable and displaceable rigid core body configured to support, from a radial inside, a carcass band toroidally bulged between said pair of bead cores;

a first building carriage configured to ~~rotatably support~~ support said toroidal building ~~drum;~~ drum in a rotatable manner around a main axis;

workstations configured to mount applicable tire components onto a tire in the course of building and having the bead cores locked by said toroidal building drum; and

an endless or ended track configured to guide a movement of said first building carriage among said workstations.

10. (Currently Amended) The tire building system according to claim 9, further comprising a ~~first~~ second building unit configured to deliver a cylindrical carcass band to said ~~building unit as a second~~ first building unit;

wherein said ~~first~~ second building unit comprises: a cylindrical building drum configured to form the carcass band; a second building carriage configured to rotatably support said cylindrical building drum; a plurality of workstations configured to mount applicable tire components onto said cylindrical building drum; and an endless or ended track configured to guide a movement of said second building carriage among said workstations.

11. (Currently Amended) The tire building system according to claim 9, wherein said track of said ~~second~~first building unit is ~~made~~-endless.

12. (Currently Amended) The tire building system according to claim 11, wherein said track of said first building unit has mutually substantially parallel straight portions, and said workstations are arranged correspondingly to both said straight portions.

13. (Currently Amended) The tire building system according to ~~claim 10~~claim 10, wherein said track of said ~~first~~second building unit is ~~made~~-straight.

14. (Previously Presented) A tire manufacturing system including a tire vulcanizing system disposed adjacently to said tire building system according to claim 9,

wherein said tire vulcanizing system comprises:

a plurality of vulcanizing stations configured to accommodate green tires conveyed from said building system, into associated vulcanizing molds to vulcanize the green tires, respectively;

a mold opening/closing station configured to open and close said vulcanizing molds taken out of said vulcanizing stations, respectively; and

a bladder attaching/detaching station configured to attach a bladder to a green tire and to detach the bladder from a vulcanized tire.

15. (Original) The tire manufacturing system according to claim 14, wherein said vulcanizing stations are arranged on an arc around said mold opening/closing station as a center.

16. (Previously Presented) A tire manufacturing method for sequentially moving a tire, in the course of building, through a plurality of workstations included in a building system to thereby sequentially mount tire components previously determined correspondingly to the workstations, respectively, onto the tire to thereby build the same into a green tire, the method comprising the steps of:

sequentially, at one or more of the workstations,
disposing a cylindrical carcass band and a pair of bead cores onto a toroidally scalable toroidal building drum to thereby lock the bead cores,
radially expanding the building drum to toroidally extend the carcass band between both bead cores, and
turning back side portions of the carcass band to radial outsides around the bead cores, respectively, and
thereafter, at another or other workstations,
mounting tire components including sidewall members onto the carcass band and bead cores while the bead cores are kept locked on the toroidal building drum, to thereby build them into a green tire; and
radially contracting the toroidal building drum, and unlocking the bead cores to detach the green tire from the building drum.

17. (New) The tire manufacturing system according to claim 9, wherein the bead cores are in a symmetrical relationship with each other to allow for symmetrical bulging of the carcass band.

18. (New) The tire manufacturing system according to claim 16, wherein the bead cores are in a symmetrical relationship with each other to allow for symmetrical bulging of the carcass band.

19. (New) The tire manufacturing system according to claim 9, wherein the bead cores are locked in a predetermined position during installation of tire components.

20. (New) The tire manufacturing system according to claim 16, wherein the bead cores are locked in a predetermined position during installation of tire components.